

ASAP!

Dart Aerospace Ltd.

44

Date: Tuesday, 10/30/2007 2:48:28 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE SUPPORT CHANGE
Job Number	: 35431		
Estimate Number	: 12739		
P.O. Number	: N/A	Part Number	: DSI9366011
This Issue	: 10/30/2007 S.O. No. : N/A	Drawing Number	: DSI9366 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 10/31/2007 Qty: 2 Um: Each
Checked & Approved By	: <u>071031</u>		
Comment	: Est Rev: A New Issue 07-02-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 07.10.13

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI9366-011 CHG001

& Holo/02

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3595	Rubber Cushion (per sq ft)
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Comment: Qty.: 0.0234 sf(s)/Unit Total : 0.0468 sf(s)

RUBBER CUSHION

2 X .75" x 4.30

Batch: B25124

SP

4.0	MS2192028 24	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: m101810

7/11/12

SP

(x2)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

& Holo/02 (x2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/30/2007 2:48:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE SUPPORT CHANGE

Job Number: 35431

Part Number: DSI9366011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI9366-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*Draft*

*7/11/02*

*SP*

*(2x)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*7/11/02*

Job Completion



*U 07.11.02*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9366	REV. A SHEET 1 OF 2
DATE 07.02.07		TITLE CROSSTUBE SUPPORT CHANGE SCALE NTS	
A	07.02.07	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 Rev. C AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 Rev. 2  
REF. CANADIAN STC: SH01-5  
REF. FAA STC: SR01304NY

For D407-667-205 Aft Crosstubes at CHG 004 or later, the D2856-600-851 Abrasion Strip has been removed, the center D2894-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D3595-075-430 Rubber Cushions have been installed underneath the MS21920-24/-25 Clamps. Amend Parts List of IIN-D206-667 Section 5 and ICA-D206-667 Section 32.8 as follows:

### **Remove:**

Item	QTY -205	Part Number	Description
15	2	D2856-600-851	ABRASION STRIP
18	2	MS21920-24	CLAMP

### **Add:**

Item	QTY -205	Part Number	Description
18	2	MS21920-25	CLAMP (OR MS21920-24)
50	2	D3595-075-430	RUBBER CUSHION

To prevent the center support from shifting on D407-667-205 Crosstubes at CHG 003 or earlier, the D2894-1 Support should be removed and re-installed as follows:

**Note:** The MS21920-24/-25 clamps are interchangeable to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nuts.

- 1) Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-24 Clamps from the crosstube that fasten the D2894-1 Supports to the crosstube.
- 3) Remove the D2856-600-851 Abrasion Strip from the crosstube per section 32.5 of ICA-D206-667.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2894-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2894-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Position and secure the D2894-1 Support on the crosstube using MS21920-24/-25 Clamps. Install a D3595-075-430 Rubber Cushion underneath each MS21920-24/-25 Clamp. Torque clamps 80-100 in-lb. Let the D407-667-205 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- 7) Re-install the D407-667-205 crosstube per Section 32.2 of ICA-D206-667.

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WORK ORDER  
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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b> <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	07.02.07
CERT. NO.:	SH01-5
ISSUE:	3

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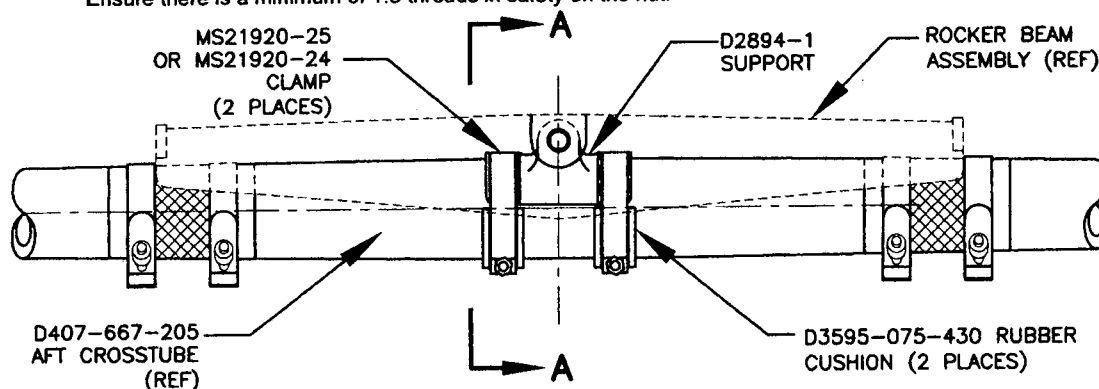
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9366	REV. A SHEET 2 OF 2
DATE 07.02.07		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS

For customers who would like to upgrade their D407-667-205 Aft Crosstubes from CHG 003 or earlier to CHG 004, the following kit can be obtained from Dart:

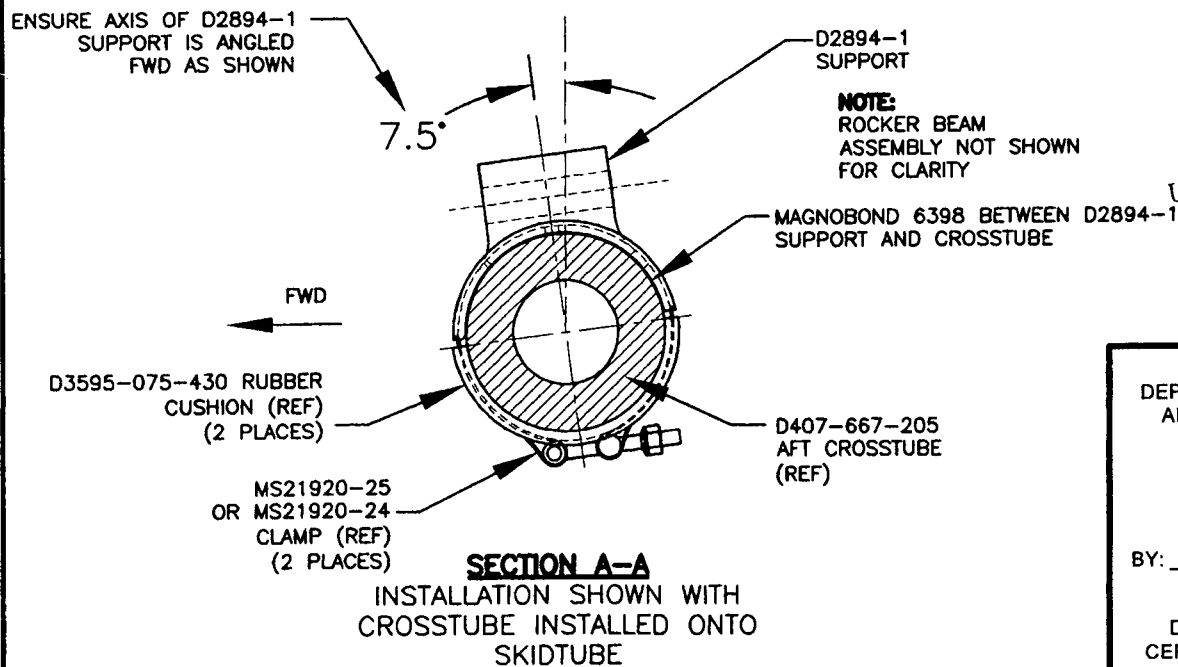
#### DSI 9366-011 PARTS LIST

QTY -011	Part Number	Description
X	DSI 9366-011	CROSSTUBE SUPPORT CHANGE
2	D3595-075-430	RUBBER CUSHION
2	MS21920-25	CLAMP (OR MS21920-24)

**Note:** The MS21920-24/-25 clamps are interchangeable to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.



**FIGURE 1 - CROSSTUBE SUPPORT  
INSTALLATION ON D407-667-205**



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NO. 39131

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *D. Shepherd*  
D. SHEPHERD (DE # 02)

DATE: 07.02.07  
CERT. NO.: SH01-5  
ISSUE: 3

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9366	REV. A SHEET 1 OF 2
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REF. CANADIAN STC: SH01-5  
REF. FAA STC: SR01304NY

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### **Remove:**

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18	2	MS21920-24	CLAMP

### **Add:**

Item	QTY -205	Part Number	Description
18	2	MS21920-25	CLAMP (OR MS21920-24)
50	2	D3595-075-430	RUBBER CUSHION

**REFERENCE ONLY**

**To prevent the center support from shifting on D407-667-205 Crosstubes at CHG 003 or earlier, the D2894-1 Support should be removed and re-installed as follows:**

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- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
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- 7) Re-install the D407-667-205 crosstube per Section 32.2 of ICA-D206-667.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.02.07  
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